

Work Order ID 70088

Thursday, May 26, 2011 1:52:29 PM

Page 1

Item ID: D2680-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Nut Plate

Start Date: 5/27/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2680

Rev B1

0.00

100



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2680
Deburr if necessary

Dwg Rev: B1

Prog Rev: B1

2-

B11-5-25

94

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B11-5-26

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Sulostre

counters
124

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- Deburr 2-C'sink as per Dwg D2680

ES 11/05/26 (24)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

SS 11/05/27 (24)

150



Powdercoat

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

Memo

0.00

Powder Coating

START TIME:

3:20

FINISH TIME:

8:05

OVEN TEMPERATURE:

8:45

24 BL 11-5-27

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

24 0 11/05/27

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Nut Plate as per Dwg D2680

SP 11/05/27 (2)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SP 11/05/27

(2)

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

Identify as per dwg & Stock Location: LC

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

BB 11/05/27

11/5/30 DJ

MF 11-05-27

Picklist Print

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Page 1

Work Order ID: 70088

Parent Item: D2680-041

Parent Item Name: Nut Plate



Start Date: 5/27/2011

Required Date: 5/27/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D 04.10.01 Added Steps 2-4, 7-8 KJ/JLM
IPP Rev:E Now on WaterJet 06-10-12 JLM
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

170

sf

152.5000

0.0131

0.275789



1010/1025 sheet 16GA



B11-5-26

Location

Loc Qty

Loc Code

MAT019

152.5

116791

34.5

117500

118

116791

24

MS20426AD3-3

Purchased

No

170

Each

2,377.000

2

40



Rivet



SB 11/05/27

Location

Loc Qty

Loc Code

ST316

2377

19099

2377

40

MS21069L4

Purchased

No

110

Each

305.0000

1

20



Nutplate



SB 11/05/27

Location

Loc Qty

Loc Code

ST302

305

106285

291

18536

14

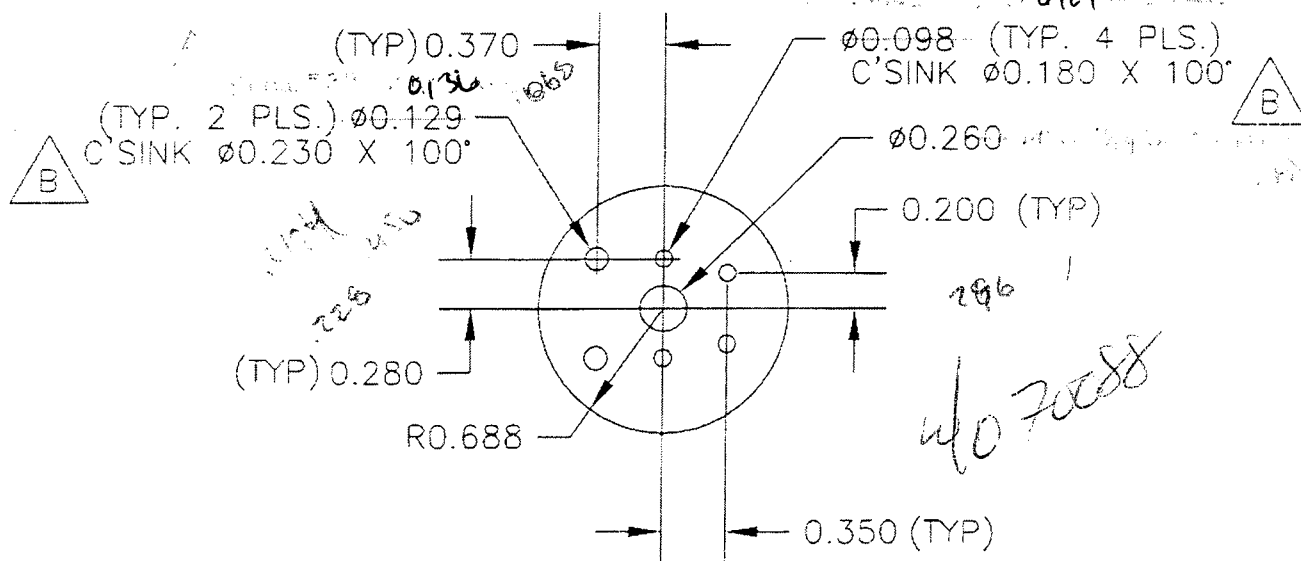
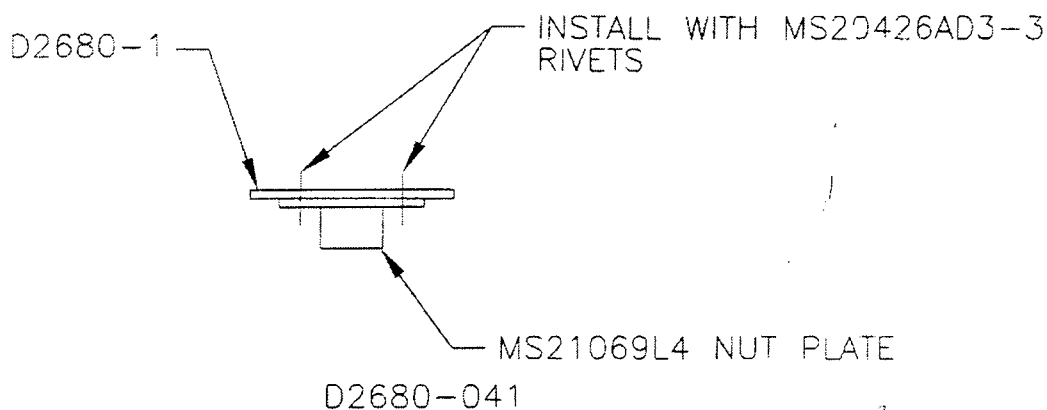
10

19



DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14		TITLE NUT PLATE	SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	

RELEASED
12.14.98



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2680-1

